

WHAT IS CLAIMED IS:

1. A toner including toner particles comprising a styrene acrylate binder and at least one colorant, and wherein the styrene acrylate binder has a weight average molecular weight of about 20 to about 30 kpse and a molecular peak of about 23 to about 28 kpse, the toner particles have a weight average molecular weight of about 28 to about 130 kpse, a number average molecular weight of about 9 to about 13.4 and a MWD of about 2.2 to about 10, and the toner particles have a cohesion of about 55 to about 98% at a mean circularity of about 0.94 to about 0.98.
2. The toner according to claim 1, wherein the binder comprises about 75 to about 85% by weight of the toner particles on a solids basis.
3. The toner according to claim 1, wherein the toner particles further comprise a wax dispersion.
4. The toner according to claim 3, wherein the wax dispersion is present in an amount of about 8 to about 11% by weight of the toner particles on a solids basis.
5. The toner according to claim 1, wherein the toner is a cyan toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis.
6. The toner according to claim 1, wherein the toner is a magenta toner, and the at least one colorant is present in an amount of about 7 to about 15% by weight of the toner particles on a solids basis.
7. The toner according to claim 1, wherein the toner is a yellow toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis.
8. The toner according to claim 1, wherein the toner is a black toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis.
9. The toner according to claim 1, wherein the toner particles further comprise polyaluminum chloride in an amount up to about 2% by weight of the toner particles on a solids basis.

10. The toner according to claim 1, wherein the toner particles further comprise a colloidal silica in an amount up to about 10% by weight of the toner particles on a solids basis.

11. The toner according to claim 1, wherein the toner particles have a melt flow index (MFI) of from about 18 to about 37 g/10 min.

12. The toner according to claim 1, wherein the toner particles have a stripping force range at 170°C of from about 7 to about 18 mg/cm<sup>2</sup>.

13. The toner according to claim 1, wherein the toner particles have an elastic modulus of about 89,000 to about 130,000 dyn/cm<sup>2</sup> at 120°C/10 rad/sec.

14. The toner according to claim 1, wherein the toner particles have a bulk density of from about 0.22 to about 0.34 g/cc.

15. The toner according to claim 1, wherein the toner particles have a compressibility of from about 33 to about 51.

16. The toner according to claim 1, wherein the toner particles further comprise one or more external additives selected from the group consisting of silica, titanium dioxide and zinc stearate.

17. The toner according to claim 1, wherein the toner particles are further mixed with carrier particles.

18. A set of toners for forming a color image, comprising a cyan toner, a magenta toner, a yellow toner and a black toner, wherein each of the cyan toner, the magenta toner, the yellow toner and the black toner comprise toner particles comprised of about 70 to about 95% by weight, solids basis, of a styrene acrylate binder, about 5 to about 15% by weight, solids basis, of a wax dispersion, and at least one colorant, and wherein the styrene acrylate binder has a weight average molecular weight of about 20 to about 30 kpse and a molecular peak of about 23 to about 28 kpse, the toner particles have a weight average molecular weight of about 28 to about 130 kpse, a number average molecular weight of about 9 to about 13.4 and a MWD of about 2.2 to about 10, and the toner particles have a cohesion of about 55 to about 98% at a mean circularity of about 0.94 to about 0.98.

19. The set of toners according to claim 18, wherein the toner particles of the cyan and the yellow toner have a weight average molecular weight of about 24 to about 34 kpse, a number average molecular weight of about 9 to about 11 kpse and a

MWD of about 2.5 to about 3.3, and wherein the toner particles of the black toner and the magenta toner have a weight average molecular weight of about 30 to about 130 kpse, a number average molecular weight of about 10 to about 14 kpse, and a MWD of about 2 to about 10.